

Work Order ID 71813

Tuesday, July 12, 2011 12:07:03 PM



Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 11-07-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

11-07-18

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-07-19

Work Order ID 71813

Tuesday, July 12, 2011 12:07:03 PM



Page 2

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/12/11



Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M 115128

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time:

Oven Temperature:

Finish Time:

7:15
320°
7:45

1 BR 11-7-20

140

Wing Walk as per dwg QSI005 4.4 Batch 117863

0.00



HandFinish

Memo

Hand Finishing

- 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
- 2- install label

1 S M 11/07/20

Tuesday, July 12, 2011 12:07:00 PM

Required Qty: 1.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	10	
69164	4	
70373	6	

Picklist Print

Tuesday, July 12, 2011 12:07:00 PM

Page 2

Work Order ID: 71813

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5

Manufactured No

100 Each

29.0000

6



Rib

Location

Loc Qty

Loc Code

WA

15

69163

15

WA005

14

67041

14



6
Pl 11.07.19

B70758 → ⑥

D4035-041

Manufactured No

100 Each

3.0000

1



Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA006

3

69727

3



1
Pl 11.07.19

①

D4035-043

Manufactured No

100 Each

2.0000

1



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA

2

69869

2



1
Pl 11.07.19

B71485 → ①

D2581

Manufactured No

100 Each

83.0000

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

83

69258

28

69739

4

70766

51



2
Pl 11.07.19

②

Tuesday, July 12, 2011 12:07:01 PM

Shop Packet Print

Page 2

Picklist Print

Tuesday, July 12, 2011 12:07:01 PM

Page 3

Work Order ID: 71813

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-7

Manufactured

No

100

Each

1.0000

1

1



Mesh (350 Basket Short, Lid)



Pl 11-07-19

Location

Loc Qty

Loc Code

FG

1

68523

1

B 72 006 → (1)

D4021-3

Manufactured

No

100

Each

4.0000

1

1



Data Plate



Pl 11-07-19

Location

Loc Qty

Loc Code

WA005

4

70240

4

(1)

D2728-3

Manufactured

No

140

Each

0.0000

1

1



Dart Logo label



M115050

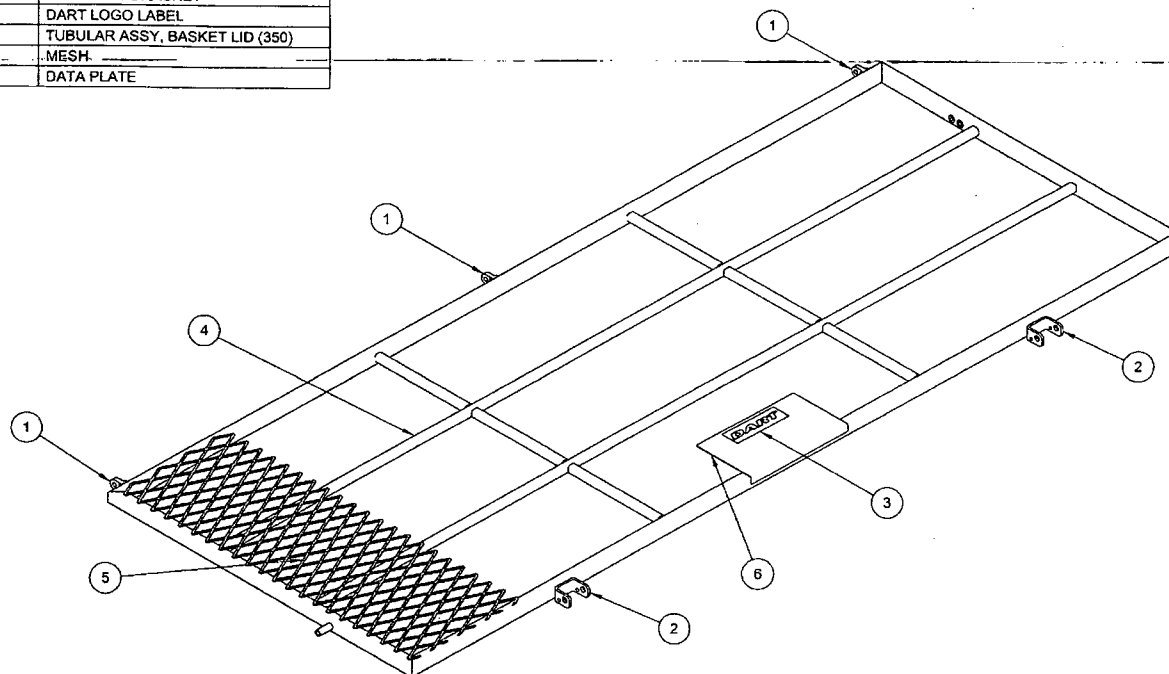
(x1) M u/c = 20

Tuesday, July 12, 2011 12:07:01 PM

Shop Packet Print

Page 3

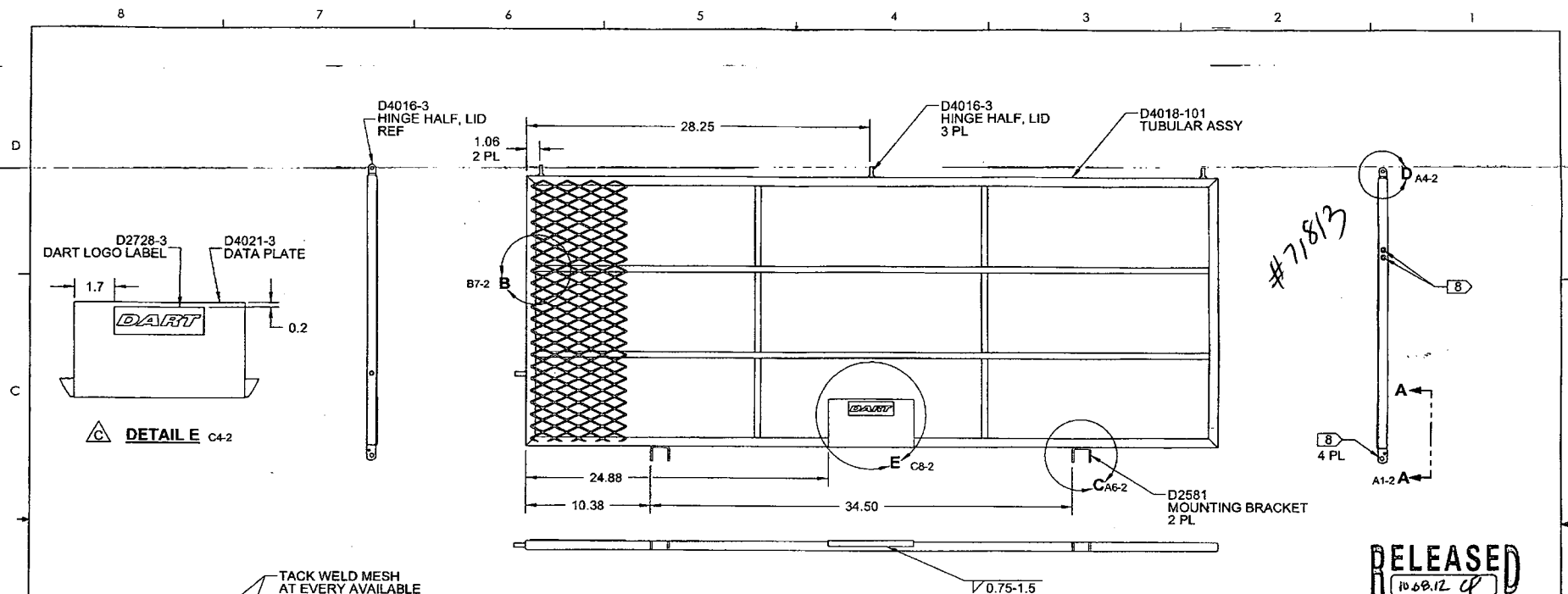
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



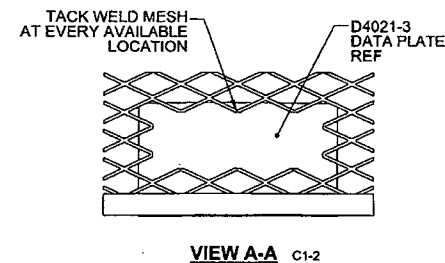
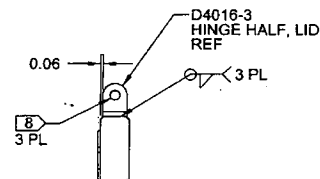
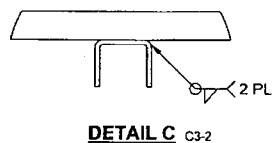
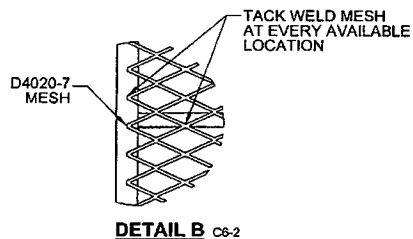
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12
ECW 10-96

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQ. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOL 3 REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. C SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) NTS SCALE COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DETAIL E C4-2



RELEASED
10.08.12

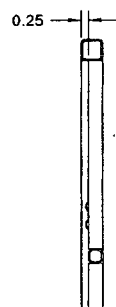
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

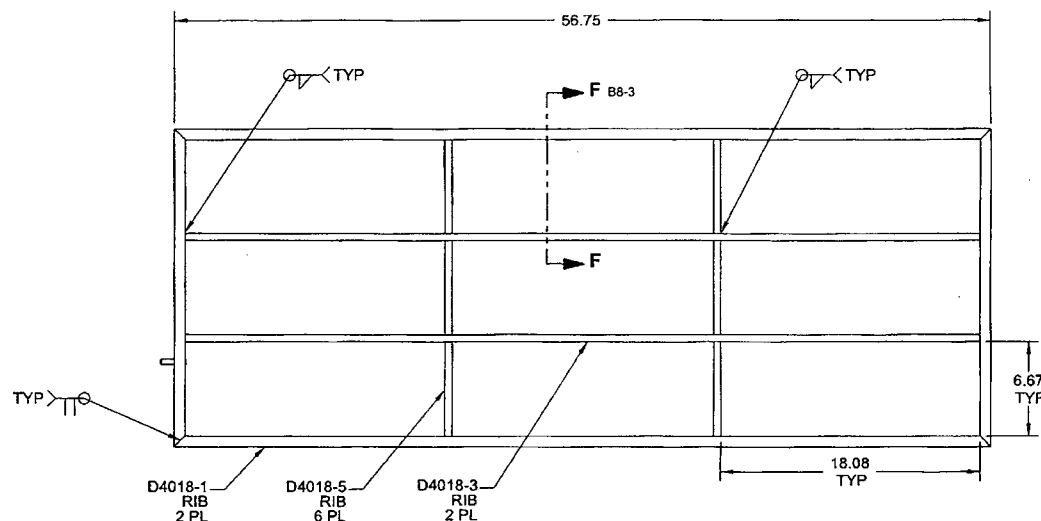
#71813

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



D4035-041
RIB ASSY, FWD

SECTION F-F C3-3



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

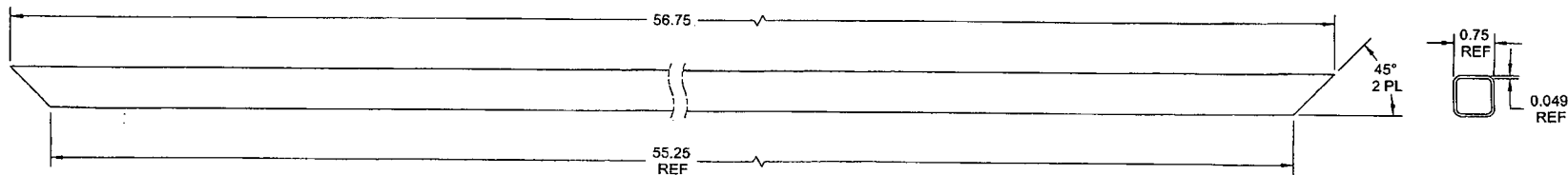
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1

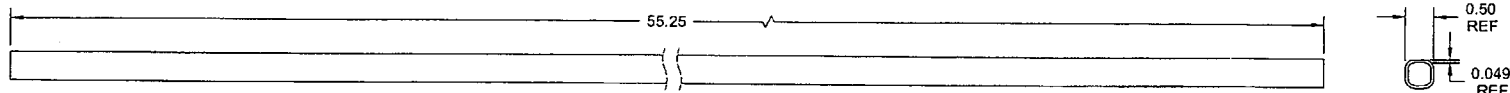
D

D



D4018-1 RIB

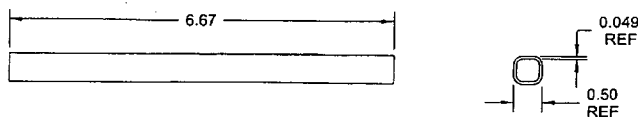
#71813



D4018-3 RIB

B

B



D4018-5 RIB

RELEASED
10.08.05

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	A15	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

A

A